

The above specification provides a basis for understanding the broad meets and bounds of the invention. The following examples and test data provide an understanding of certain specific embodiments of the invention and contain a best mode. The invention will be further described by reference to the following detailed examples.

- 5 These examples are not meant to limit the scope of the invention that has been set forth in the foregoing description. Variation within the concepts of the invention is apparent to those skilled in the art.

Example 1

- 10 A powder premix was prepared by combining the components identified in Table 1.

Table 1

COMPONENT	AMOUNT
Tripolyphosphate (large granular)	92.3%
Abil-B-8852	1.6%
EO/PO block nonionic (5 blocks) terminated with PO	3.6%
SMEA	0.6%

- 15 The tripolyphosphate was added to a ribbon mixer. The ribbon mixer was turned on and the Abil surfactant (nonionic siloxane surfactant) was added and allowed to mix for a few minutes. A premix of the EO/PO block nonionic and the SMEA (stearic monoethanol amide) was heated to above 185°F and then added to the ribbon mixer. The mixture was allowed to mix for a few minutes. The extrusion process was run in a 5 inch Readco continuous processor equipped with all feed screw except the second to last element being a helical paddle and the last element being a reverse helical paddle.

- 20 All powders were fed in the first powder port and all liquids in the first liquid port of the 5 inch Readco continuous processor.

Liquid feed streams

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- | | |
|--|--------|
| Hamp EX-80 (Na ₅ diethylene triamine penta acetate available from Hampshire Chemical Company) | 14.00% |
| benzyl ether of polyethoxylated linear alcohol | 2.5% |
| EO/PO block nonionic (5 blocks) terminated with PO | 0.215% |

Powder feed streams

dense ash (sodium carbonate)	34.69%
sodium bicarbonate	12.00%
powder premix (Table 1)	36.60%

- 5 The production rate for this experiment was 50 pounds/min.
The product extruded well.

Example 2

- The procedure of Example 1 was repeated except that sodium bicarbonate was not added. The resulting composition solidified very slowly and was soft exiting the
10 continuous processor.

Example 3

The premixes identified in Table 2 were processed in the 5 inch Readco continuous processor described in Example 1.

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Table 2

	Formula %	Total Water	Premix %	RM with P	% P
Premix 1:					
Water	1.2600	1.2600	8.394404		
Citric acid, anhydrous	0.4500		2.998001		
Hamp-ex 80					
(Water from neut. of NaOH in Hamp-ex 80)	13.3000	6.6500	88.607509		
		0.0784			
Premix 2:					
Powder Premix	34.4400			32.46831	8.198248
Premix 3:					
EO/PO block nonionic (5 blocks) terminated with PO	2.4800				
benzyl ether of polyethoxylated linear alcohol	0.2100				
Premix 4:					
Dense Ash	42.4200				

Sodium Bicarbonate	5.4400				
Total	100.0000			Total P	8.198248
(Total water)		7.9884000			
(Moles water)		0.4438002			
(Moles ash)		0.4001887			
(% ash monohydrate)		110.89774			

The product solidified faster than the product for Example 1.

It is believed that the citric acid neutralized caustic in the Hamp-ex 80 and neutralized a portion of the dense ash to form sesquicarbonate *in situ*.

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Example 4

The procedure of Example 1 was repeated using the formulation provided in Table 3.

Table 3

	Formula %	Total Water	Premix %	RM with P	% P
Premix 1:					
Water	0.0000	0.0000	0		
Citric acid, anhydrous	1.0620		7.241238		
Hamp-ex 80	13.6040	6.8020	92.75876		
(Water from neut. of NaOH in Hamp-ex 80)	13.3000	0.0802			
Premix 2:					
Powder Premix	35.2020			33.18669	8.379638
Premix 3:					
EO/PO block nonionic (5 blocks) terminated with PO	2.5380				
benzyl ether of polyethoxylated linear alcohol	0.2180				
Premix 4:					
Dense Ash	45.8760				
Sodium Bicarbonate	1.5000				
Total	100.0000			Total P	8.379638

(Total water)		6.8822			
(Moles water)		0.3823442			
(Moles ash)		0.4327925			
(% ash monohydrate)		88.343546			

The product solidified faster than the product in Example 1. It is believed that the citric acid neutralized caustic in the Hamp-ex 80 and neutralized a portion of the dense ash to form sesquicarbonate *in situ*.

- 5 The above specification, examples and data provide a complete description of the manufacture and use of the composition of the invention. Since many embodiments of the invention can be made without departing from the spirit and scope of the invention, the invention resides in the claims hereinafter appended.